










Prism-Cutter Ø60 Z24

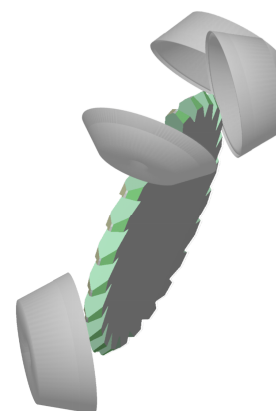
A4-110

The V-Shaped prism-cutter is manufactured from a blank disk in one setup. The usage of 11V9 wheels for the V-Profile allows easily to grind straight and radial clearances. The right picture shows a sample ground with radial clearance.



1. Cycletime for Production

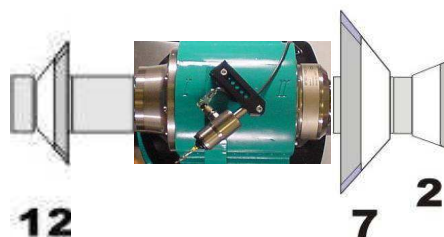
Tool specifications					
Diameter 60 mm, Z 24, Length of cutting edge 3 mm, Helix angle 0°					
Material HM					
Operations					
Feed [mm/Min]	2000	70	80	80	80
Power [kW]		4	1	1	1
Cutting feed [m/s]		20	22	22	22
Used wheels					
Grinding time [s]	14	184	181	181	181
Total cycle time	12 Min 20				



The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

7 Ø125 12V9 D64
2 Ø75 11V9 D64
12 Ø75 12V9 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR, NORMA CFG
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 4.2

responsible engineer: OP, 7.4.07

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